

# Work Order ID 80700

February-27-12 2:53:42 PM

**\*80700\***

Page 1

Item ID: D4106-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Spacer, Sill Doulber  
 Start Date: 27/02/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 12/03/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4106	A

100 0.00

**\*100\*** Waterjet Memo 0.00 B 12-3-26

FLOW CNC Waterjet 1-Cut as per Dwg  
 Ky DEK Dwg Rev: A  
 Prog Rev: 2  
 2-Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00

**\*110\*** QC Memo 0.00 B 12-3-26

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check 0.00

**\*120\***

QC

Memo

0.00

5/2/3/20

(40)

Quality Control

130 Identify as per dwg & Stock Location: 127 0.00

**\*130\***

Packaging

Memo

0.00

Packaging

6/23/20 (10)

140 QC21- Final Inspection - Work Order Release 0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/3/29

12/03/20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

February-27-12 2:53:45 PM

Page 1

Work Order ID: 80700

\*80700\*

Parent Item: D4106-5

\*D4106-5\*

Parent Item Name: Spacer, Sill Doulber

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 52068		Purchased	No			100	sf	798.2216	0.2109	1.776	2.		

\*MKYD6185S 080-P3-52068\*

\*\*

B12-3-26

Kydex steel grey

Location

Loc Qty

Loc Code

therm

798.2215592

111807

10.4896282

119476

787.731931

119476

(10)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

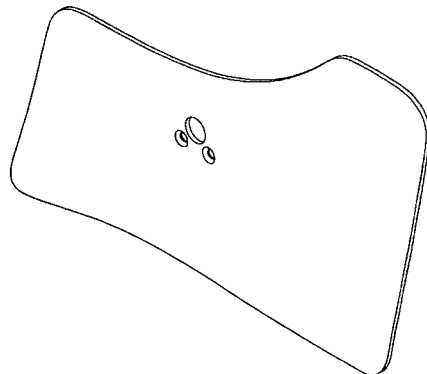
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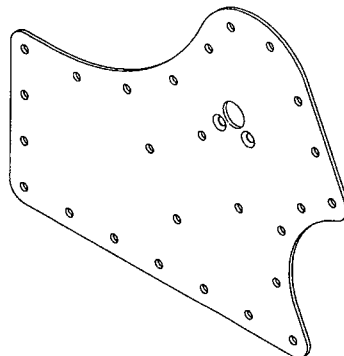
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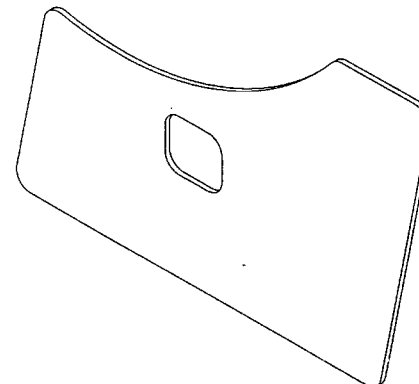




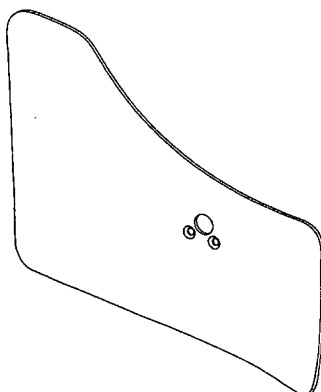
**D4106-1 SILL DOUBLER, LH**



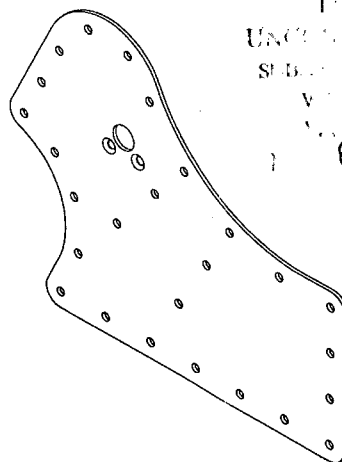
**D4106-3 CREW DOOR DOUBLER, LH**



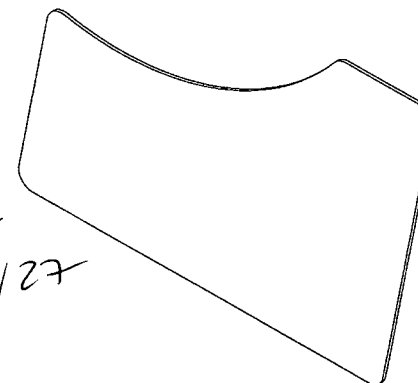
**D4106-5 SPACER, SILL DOUBLER**



**D4106-2 SILL DOUBLER, RH**






**D4106-4 CREW DOOR DOUBLER, RH**



**D4106-7 TEMPLATE**

UNC  
S  
80700 MLJ  
12/02/27

**RELEASED**  
2010-09-23  
JPH

A		NEW ISSUE		JPH	10.07.15
REV.		DESCRIPTION		BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH				
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D4106		SHEET 1 OF 5	
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



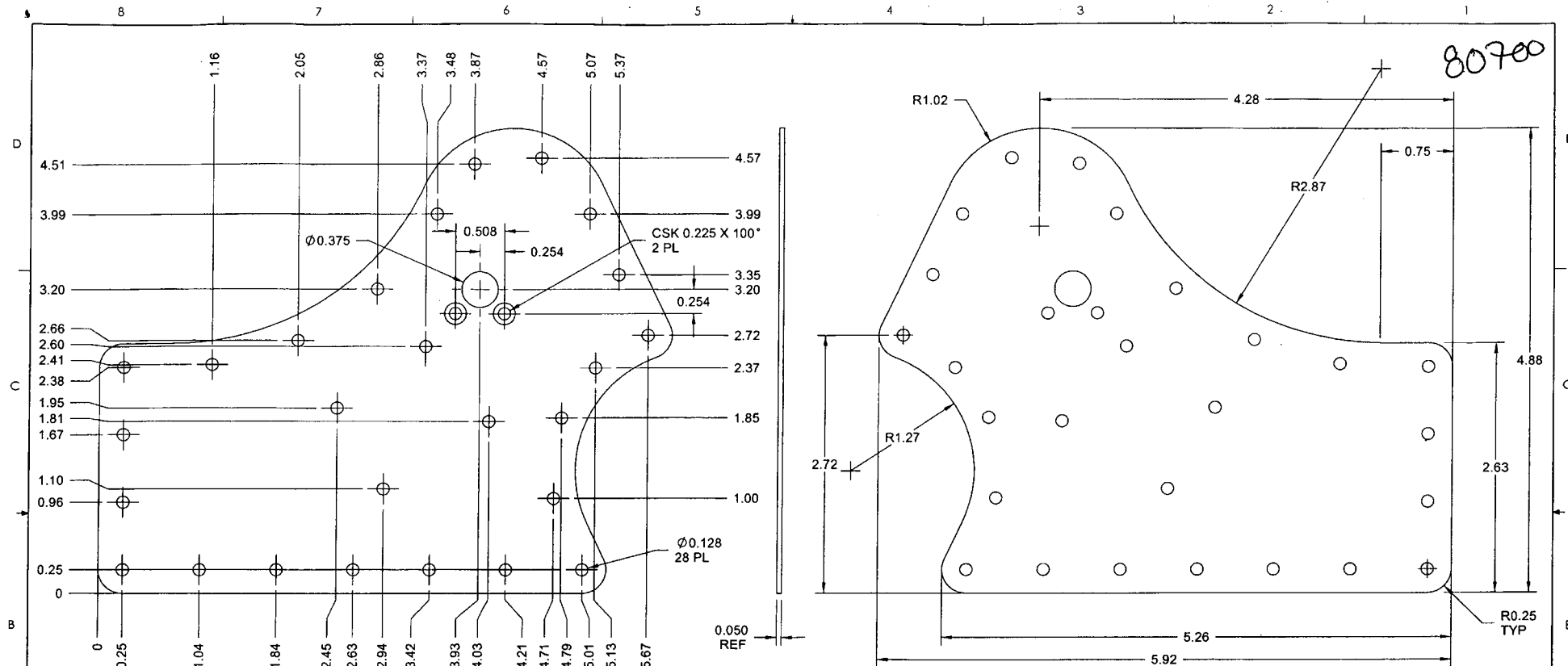
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**D4106-3 CREW DOOR DOUBLER, LH**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

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2010-09-23  
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DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4106	SHEET 3 OF 5
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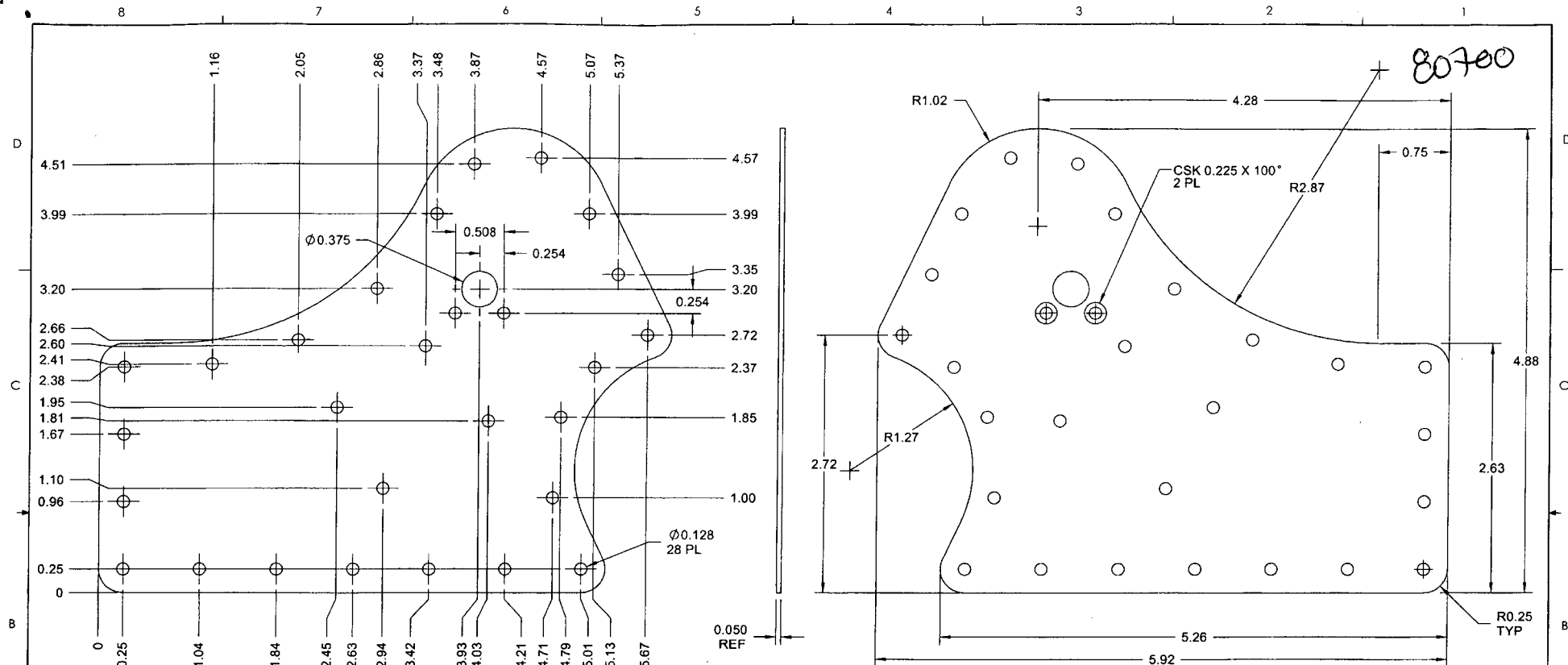
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4106-4 CREW DOOR DOUBLER, RH**

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
- 7) WEIGHT: 0.27 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4106</b>	REV. A
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2010-09-23

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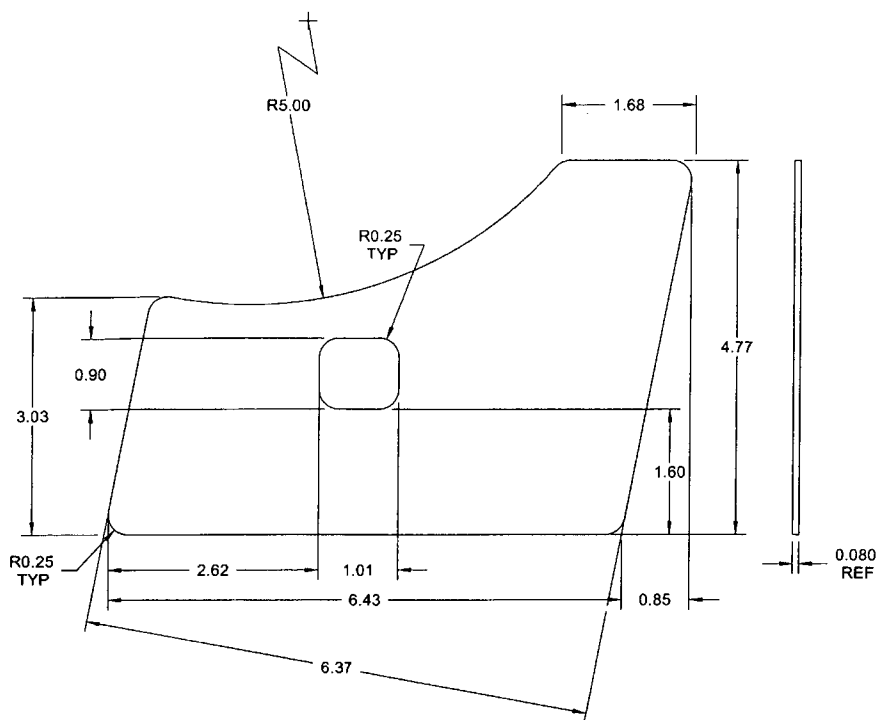
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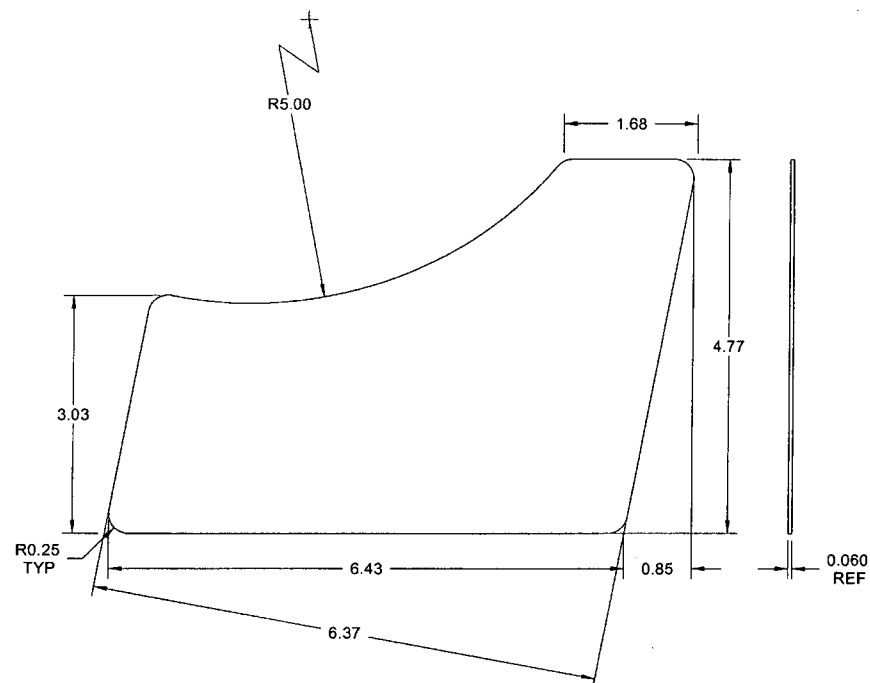




**D4106-5 SPACER, SILL DOUBLER**

**NOTES:**

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK  
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015  
-7: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs  
-7: N/A



**D4106-7 TEMPLATE**

**RELEASED**  
2010-09-23  
JW

DESIGN	JPH	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	JPH	<b>D4106</b>	SHEET 5 OF 5
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